

Work Order ID 132374

May-07-15 2:34:47 PM

132374

Page 1

Item ID: D2932-2

Revision ID:

Item Name: Saddle RH Out, 206

Start Date: 5/07/15

Start Qty: 8.00

Required Date: 5/07/15

Req'd Qty: 8.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: *W*

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2932

Rev C

100

0.01

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.11

Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

DAS

20

9-89

DAS

44

9-89

15/05/27

15/05/28

110

0.00

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.28

Machine Keyway and inspect per attached dimension sheet

DAS

44

9-89

15/05/28

120

0.00

120

QC

Quality Control

QC1- Inspection performed by CMM

Memo

0.00

DAS

44

9-89

15/05/28

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 132374

132374

Item ID: D2932-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle RH Out, 206
 Start Date: 5/07/15 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130						2	0		SL / 15/05/28
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						2	0	15-5-29	045 34 9.88
HandFinish	Memo	0.01							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150						2	0	15-5-29	045 34 9.88
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:20 FINISH TIME: 8:58								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐																							
Misidentified ☐	Past Due ☐																								

Work Order ID 132374

132374

Page 3

Item ID: D2932-2
 Revision ID:
 Item Name: Saddle RH Out, 206
 Start Date: 5/07/15 Start Qty: 8.00
 Required Date: 5/07/15 Req'd Qty: 8.00
 Reference:

Accept ***N900040100***
 Setup Start ***NS1***
 Stop ***NS2***
 Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

(2) 15-05-29 DAS
9
9-89

170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									

PPF
 50 121510 X1
 5T 396 X1

1# MAY 29 2015

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									

MLC MAY 29 2015

MF
 15-5-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																					

Picklist Print

May-07-15 2:34:46 PM

Page 1

Work Order ID: 132374

132374

Parent Item: D2932-2

D2932-2

Parent Item Name: Saddle RH Out, 206

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	25.0000	1	8			
D6101-003									**	8			
Saddle Billet, 7075													

DAS
20 15-05-27
9-89

Location

Loc Qty

Loc Code

MAT044

25

120394

1

128906

2

129920

6

130770

6

131023

10

2
4
2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER :					

DART AEROSPACE LTD	Work Order:	132374
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

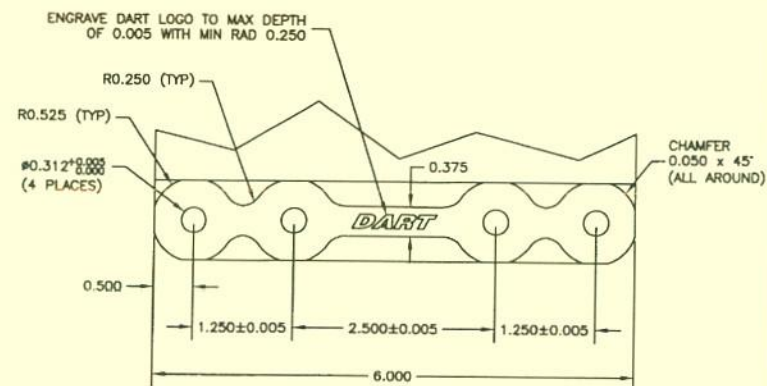
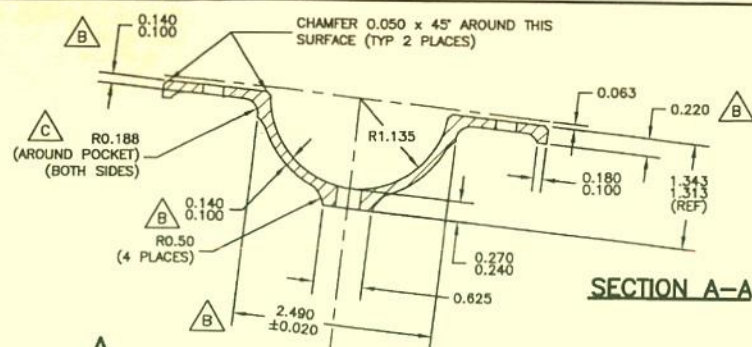
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.114	.110				
B	0.100	0.140		.118	.114				
C	0.100	0.140		.115	.115				
D	0.210	0.230		.218	.221				
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511				
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238				
N	0.100	0.140		.120	.121				
O	0.540	0.560		.548	.548				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.718	3.718				
R	2.470	2.510		2.491	2.491				
S	0.240	0.270		.250	.247				
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.135	1.139	1.1345			
Y	1.565	1.585		1.576	1.579	1.575			
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	44
Date:	15/05/28

Audited by:	J. [Signature]
Date:	15/05/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]

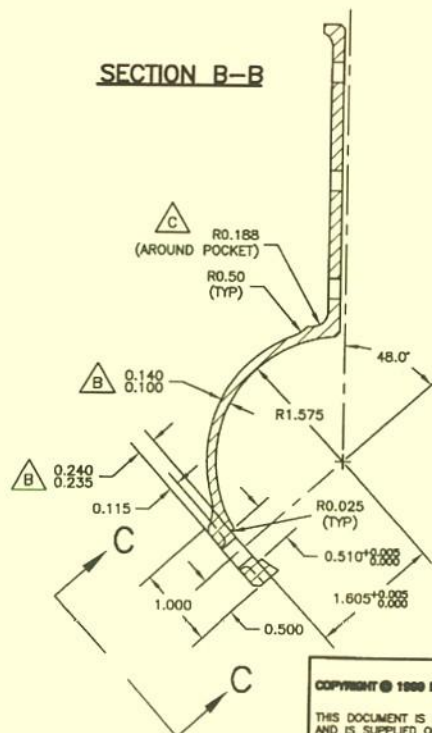
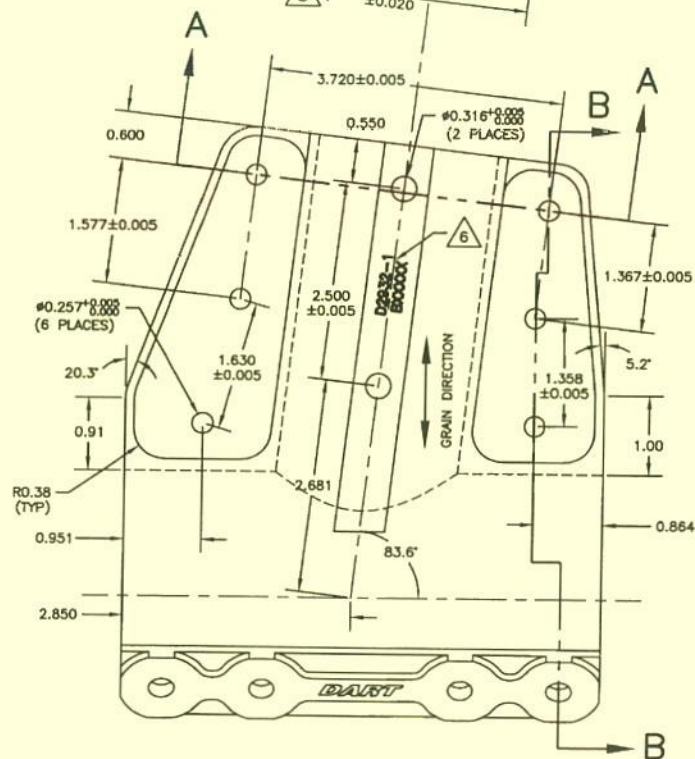
0-10
10
DV.



D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		SCALE
		2:3



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DART DART AEROSPACE USA, INC.
BELLFLORE, WA

DRAWING NO. D2932
REV. C
SHEET 1 OF 1

RELEASED

07-02-02



Part Number: D2932-2	Rev: C	- Page 1 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 132374

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual			
A	0.120	0.020 -0.020	0.114	0.110			
B	0.120	0.020 -0.020	0.118	0.114			
C	0.120	0.020 -0.020	0.115	0.115			
D	0.2200	0.0100 -0.0100	0.2215	0.2225			
E	1.2500	0.0050 -0.0050	1.2468	1.2485			
F	1.2500	0.0050 -0.0050	1.2493	1.2496			
G	2.5000	0.0050 -0.0050	2.5029	2.5001			
H	0.510	0.005 0.000	0.511	0.511			
I	1.5770	0.0050 -0.0050	1.5771	1.5776			
J	2.5000	0.0050 -0.0050	2.4996	2.4992			
K Diameter	0.2570	0.0050 -0.0010	0.2577	0.2560			
L Diameter	0.3120	0.0050 -0.0010	0.3127	0.3127			
M	0.235	0.005 0.000	0.238	0.238			
N	0.1200	0.0200 -0.0200	0.1204	0.1216			
O	0.5500	0.0100 -0.0100	0.5486	0.5495			
P	0.5000	0.0100 -0.0100	0.4998	0.5019			
Q	3.7200	0.0050 -0.0050	3.7173	3.7188			

Measured by:
Mathieu Lamarche

Date:
2015-5-28

Audited by: *[Signature]*

Date: *15/05/02*

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0.110	0.110	0.110	0.110
0.200	0.200	0.200	0.200
0.300	0.300	0.300	0.300
0.400	0.400	0.400	0.400
0.500	0.500	0.500	0.500
0.600	0.600	0.600	0.600
0.700	0.700	0.700	0.700
0.800	0.800	0.800	0.800
0.900	0.900	0.900	0.900
1.000	1.000	1.000	1.000
1.100	1.100	1.100	1.100
1.200	1.200	1.200	1.200
1.300	1.300	1.300	1.300
1.400	1.400	1.400	1.400
1.500	1.500	1.500	1.500
1.600	1.600	1.600	1.600
1.700	1.700	1.700	1.700
1.800	1.800	1.800	1.800
1.900	1.900	1.900	1.900
2.000	2.000	2.000	2.000
2.100	2.100	2.100	2.100
2.200	2.200	2.200	2.200
2.300	2.300	2.300	2.300
2.400	2.400	2.400	2.400
2.500	2.500	2.500	2.500
2.600	2.600	2.600	2.600
2.700	2.700	2.700	2.700
2.800	2.800	2.800	2.800
2.900	2.900	2.900	2.900
3.000	3.000	3.000	3.000
3.100	3.100	3.100	3.100
3.200	3.200	3.200	3.200
3.300	3.300	3.300	3.300
3.400	3.400	3.400	3.400
3.500	3.500	3.500	3.500
3.600	3.600	3.600	3.600
3.700	3.700	3.700	3.700
3.800	3.800	3.800	3.800
3.900	3.900	3.900	3.900
4.000	4.000	4.000	4.000
4.100	4.100	4.100	4.100
4.200	4.200	4.200	4.200
4.300	4.300	4.300	4.300
4.400	4.400	4.400	4.400
4.500	4.500	4.500	4.500
4.600	4.600	4.600	4.600
4.700	4.700	4.700	4.700
4.800	4.800	4.800	4.800
4.900	4.900	4.900	4.900
5.000	5.000	5.000	5.000
5.100	5.100	5.100	5.100
5.200	5.200	5.200	5.200
5.300	5.300	5.300	5.300
5.400	5.400	5.400	5.400
5.500	5.500	5.500	5.500
5.600	5.600	5.600	5.600
5.700	5.700	5.700	5.700
5.800	5.800	5.800	5.800
5.900	5.900	5.900	5.900
6.000	6.000	6.000	6.000
6.100	6.100	6.100	6.100
6.200	6.200	6.200	6.200
6.300	6.300	6.300	6.300
6.400	6.400	6.400	6.400
6.500	6.500	6.500	6.500
6.600	6.600	6.600	6.600
6.700	6.700	6.700	6.700
6.800	6.800	6.800	6.800
6.900	6.900	6.900	6.900
7.000	7.000	7.000	7.000
7.100	7.100	7.100	7.100
7.200	7.200	7.200	7.200
7.300	7.300	7.300	7.300
7.400	7.400	7.400	7.400
7.500	7.500	7.500	7.500
7.600	7.600	7.600	7.600
7.700	7.700	7.700	7.700
7.800	7.800	7.800	7.800
7.900	7.900	7.900	7.900
8.000	8.000	8.000	8.000
8.100	8.100	8.100	8.100
8.200	8.200	8.200	8.200
8.300	8.300	8.300	8.300
8.400	8.400	8.400	8.400
8.500	8.500	8.500	8.500
8.600	8.600	8.600	8.600
8.700	8.700	8.700	8.700
8.800	8.800	8.800	8.800
8.900	8.900	8.900	8.900
9.000	9.000	9.000	9.000
9.100	9.100	9.100	9.100
9.200	9.200	9.200	9.200
9.300	9.300	9.300	9.300
9.400	9.400	9.400	9.400
9.500	9.500	9.500	9.500
9.600	9.600	9.600	9.600
9.700	9.700	9.700	9.700
9.800	9.800	9.800	9.800
9.900	9.900	9.900	9.900
10.000	10.000	10.000	10.000

TRAC

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Part Number:
D2932-2

Rev:
C

- Page 2 -

Description:
SADDLE OUTSIDE

Inspection Dwg:
D2932

Work Order:
132374

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual			
R	2.4900	0.0200 -0.0200	2.4918	2.4926			
S	0.255	0.015 -0.015	0.250	0.247			
T	0.140	0.040 -0.040	0.135	0.135			
U	1.6300	0.0050 -0.0050	1.6307	1.6296			
V	1.3670	0.0050 -0.0050	1.3678	1.3671			
W Diameter	0.3160	0.0050 -0.0010	0.3155	0.3150			
X	1.135	0.010 -0.010	1.135	1.139			
Y	1.575	0.010 -0.010	1.576	1.579			
Z Radius	0.1880	0.0100 -0.0100	0.1956	0.1953			

Measured by:
Mathieu Lamarche

Date:
2015-5-28

Audited by:

Date:

SOLE 000

Date:

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